

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000856**Date Inspected:** 14-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Fu Guo Gan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Mock-up 114**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the Magnetic Particle Testing (MT) of the Caltrans Mock-up # 114.00 and Welding of Orthotropic Box Girder (OBG), for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector witnessed ZPMC Quality Control (QC) Inspector Mr. Cai Xin Xin performing MT of Mock-up # 114.00 Skin Plate C at weld MA111 weld # 3 and 4. Testing was performed on a 150 mm area area that was affected by heat straightening. Mr. Cai found the weld to be acceptable. ZPMC QC Inspector Mr. Zhou Dongyun perform MT of weld # 2 post heat straightening. Mr. Dongyun found the weld to be acceptable. Caltrans QA Inspector Viars performed MT of the above mentioned locations. Please see MT report TL 6028, generated on this date for further information.

Caltrans QA Inspector Viars observed ZPMC welder Mr. Sun Ti Yu performing Submerged Arc Welding of OBG bottom deck plate 66A to 66B. Inspector Viars found the welding appeared to be in conformance with the specified Welding Procedure Specification (WPS-2231-B-U2-1F. The attached photo below illustrates pre heating of the bottom deck plate weld.

The Caltrans QA Inspector observed MT of the above mentioned items and welding observed appeared to be in general conformance with AWS D1.5 2002 requirements.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
